

# Work Order ID 70211

Tuesday, May 31, 2011 11:36:42 AM



**PRELIMINARY ISSUE**

Page 1

Item ID: D206-628-026BL

Accept



Setup Start



Revision ID: PRELIM

Item Name: Crew Step, RH, Blue

Stop



Start Date: 5/31/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/8/2011 Req'd Qty: 2.00



Customer:



Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 11-05-31

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4308

A

IIN-D206-628

PG1

*G CP 11.06.06*

100

0.00



DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP D206-628-026  
CHG 001

*(not created yet)*

*8 u106608*

*for CL 11-6-6*

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

*11/6/10*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 70211

Tuesday, May 31, 2011 11:36:42 AM



Page 2

Item ID: D206-628-026BL

Accept



Setup Start



Revision ID: PRELIM

Item Name: Crew Step, RH, Blue

Stop



Start Date: 5/31/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/8/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220  QC Quality Control	QC4- 100% Inspect kits for completeness  Memo	0.00 0.00	→ inspects to Rev G IIW instruction only						
			11/06/06 (XZ)						
230  Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo Package per PPP D206-628-026	0.00 0.00							11/06/06 (2)
240  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							11/06/06

POSITIVE RECALL

EFFECTIVE 11/05/11 AUTH W

RELEASED RP DATE 11.06.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 31, 2011 11:36:48 AM

Page 1

Work Order ID: 70211

Parent Item: D206-628-026BL

Parent Item Name: Crew Step, RH, Blue

Start Date: 5/31/2011

Required Date: 6/8/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev A 11.05.26 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
Sr D4308-042 ! Step, RH Crew		Manufactured	No				Each	0.0000	+1 12				
Sr D2731-7RG Mounting Lug		Manufactured	No				Each	0.0000	+2 4				
Sr D3394-3RG Lug		Manufactured	No				Each	0.0000	+2 4				
Sr D4309-1 Bushing		Manufactured	No				Each	20.0000	+2 4				
AN4-11A Bolt		Purchased	No				Each	298.0000	+4 8				

## Location

139e  
70099

## Loc Qty

20  
20

## Loc Code

## Location

ST356  
117872  
ST357  
110382  
115316

## Loc Qty

100  
100  
198  
1  
197

## Loc Code

11/6/6 SD (20)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 31, 2011 11:36:48 AM

Page 2

Work Order ID: 70211

Parent Item: D206-628-026BL

Parent Item Name: Crew Step, RH, Blue

Start Date: 5/31/2011

Required Date: 6/8/2011

Start Qty: 2.00

Required Qty: 2.00

S<sub>2</sub> AN4-12A  
Bolt

Purchased No

Each 213.0000



8  
sf

Location

Loc Qty

Loc Code

ST357

213

115422

113

117508

100

8

S<sub>2</sub> AN4-15A  
Bolt

Purchased No

Each 391.0000



4  
sf

Location

Loc Qty

Loc Code

ST308

6

116786

6

ST357

200

117423

200

ST358

185

117794

34

117854

51

117872

100

9

S<sub>2</sub> MS21042-4  
USE MS21042L4

Purchased No

Each 252.0000



12

M116823 11/6/6 sf(20)

Location

Loc Qty

Loc Code

ST299

252

100743

9

5389

78

5461

3

6844

19

7690

24

8182

115

9229

4

Tuesday, May 31, 2011 11:36:48 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

Tuesday, May 31, 2011 11:36:48 AM

Page 3

Work Order ID: 70211

Parent Item: D206-628-026BL

Parent Item Name: Crew Step, RH, Blue

Start Date: 5/31/2011

Required Date: 6/8/2011

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0463J

Purchased

No

Each

3,635.000

12



Washer



11616 SP 2

Location

Loc Qty

Loc Code

FP-B

8

116805

8

ST298

3627

116025

26

116805

0

117291

1001

117460

1600

117591

1000

12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

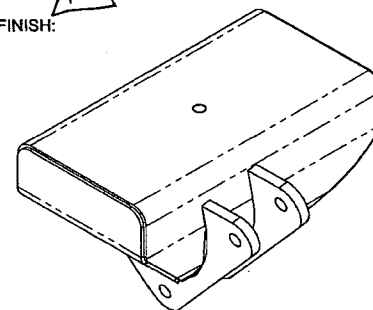
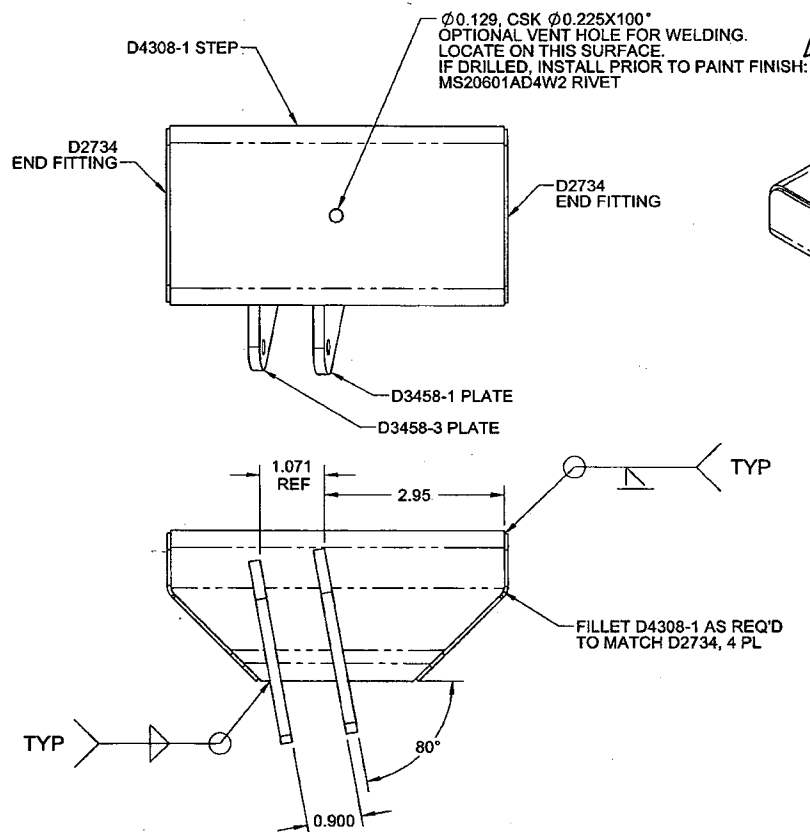
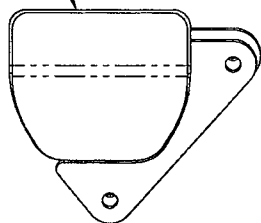
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4308-041	STEP, LH CREW
2	1	D4308-1	STEP
3	2	D2734	END PLATE
4	1	D3458-1	PLATE
5	1	D3458-3	PLATE
6	1	MS20601AD4W2	RIVET (OPTIONAL)

APPLY BLACK  
ANTI-SKID ON TOP  
SURFACE TO BOTTOM  
OF TOP RADIUS



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 70095 10211  
11-05-24

PRELIMINARY ISSUE  
Rev. PAZ 11.01.13

### D4308-041 STEP, LH CREW

#### NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4308-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.47 lb
- 8) WELDING: PER DART QSI 004

PAZ	ADD WING WALK, VENT HOLE	CP	11.01.13
REV.	NEW ISSUE	CP	10.12.17
DESIGN		BY	DATE
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.17		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.  
**D4308**

REV. 1 OF 3

TITLE  
**STEP, CREW**

SCALE  
NTS

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

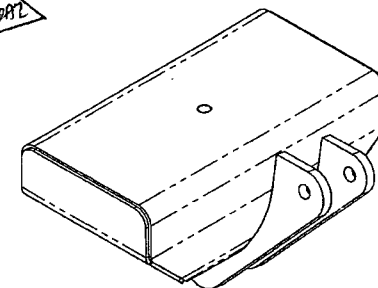
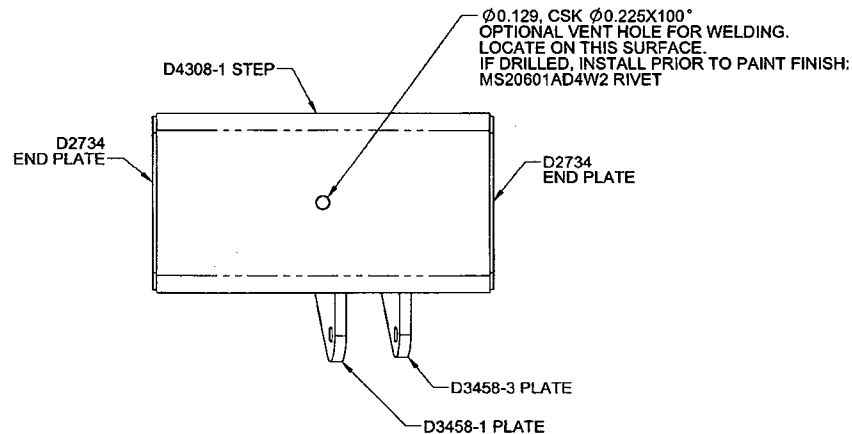
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

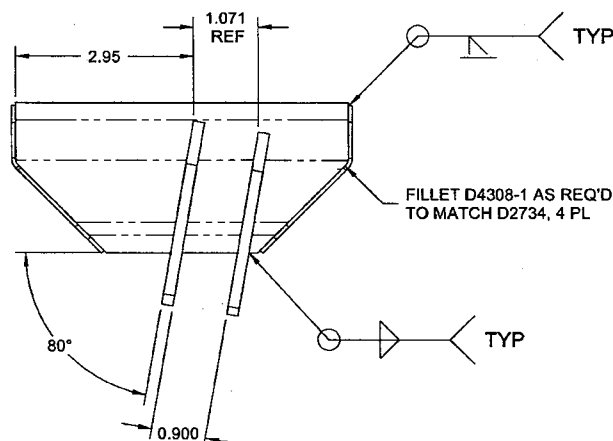
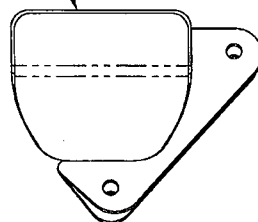
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -042	P/N	DESCRIPTION
1	X	D4308-042	STEP, RH CREW
2	1	D4308-1	STEP
3	2	D2734	END PLATE
4	1	D3458-1	PLATE
5	1	D3458-3	PLATE
6	1	MS20601AD4W2	RIVET (OPTIONAL)



APPLY BLACK  
ANTI-SKID ON TOP  
SURFACE TO BOTTOM  
OF TOP RADIUS



### D4308-042 STEP, RH CREW

#### NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4308-042" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.47 lbs
- 8) WELDING: PER DART QSI 004

**PRELIMINARY ISSUE**

Ra PAZ 11.01.13

DESIGN	<i>PAZ</i>	<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4308	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		STEP, CREW	NTS
DATE	10.12.17	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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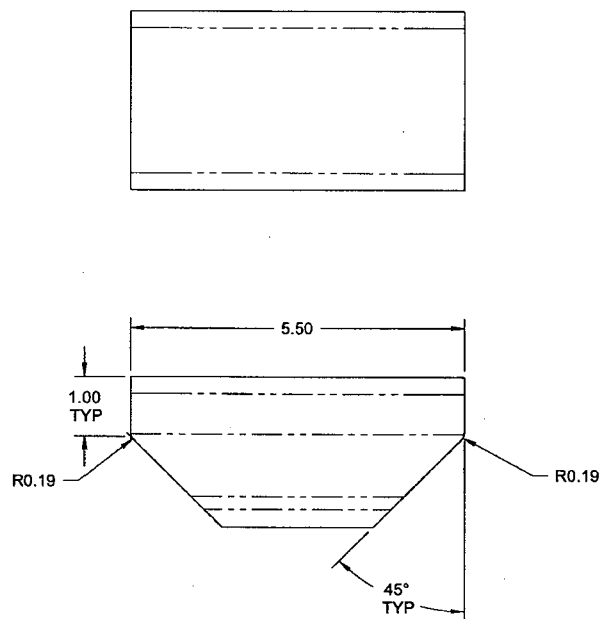
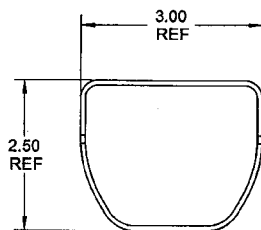
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**D4308-1 STEP**

*WLB 70098  
70211*

**PRELIMINARY ISSUE**

*REV D42 CP 11.01.13*

**NOTES:**

- 1) MATERIAL: MAKE FROM D2622 EXTRUSION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.33 lbs

DESIGN	<i>Q2</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>Q2</i>	HAWKESSBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. <i>A</i>
MFG. APPR.		D4308	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		STEP, CREW	NTS
DATE	10.12.17	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



REFERENCE ONLY

DART AEROSPACE USA, INC.

IIN-D206-628  
Page 19 of 19

#### 5.4 CREW STEP PARTS LIST

Qty -015	Qty -016	Qty -025	Qty -026	Qty -035	Qty -036	Part Number	Description
X						D206-628-015	CREW STEP, LH 206A/B
	X					D206-628-016	CREW STEP, RH 206A/B
		X				D206-628-025	CREW STEP, LH 206L/L-1/L-3/L-4
			X			D206-628-026	CREW STEP, RH 206L/L-1/L-3/L-4
				X		D206-628-035	CREW STEP, LH 407
					X	D206-628-036	CREW STEP, RH 407
				2	2	D2731-3RG	MOUNTING LUG
2	2	2	2			D2731-7RG	MOUNTING LUG
				2	2	D3394-1RG	MOUNTING LUG
2	2	2	2			D3394-3RG	MOUNTING LUG
		1		1		D4308-041	CREW STEP, LH
			1		1	D4308-042	CREW STEP, RH
2	2	2	2	2	2	D4309-1	BUSHING
1						D4357-041	CREW STEP, LH
	1					D4357-042	CREW STEP, RH
		4	4			AN4-11A	BOLT
4	4	4	4	4	4	AN4-12A	BOLT
2	2	2	2	2	2	AN4-15A	BOLT
6	6	6	6	6	6	MS21042-4	NUT
6	6	6	6	6	6	NAS1149D0463J	WASHER (AN960JD416)

#### 5.5 MAINTENANCE STEP PARTS LIST

Qty -017	Qty -018	Qty -027	Qty -028	Qty -037	Qty -038	Part Number	Description
X						D206-628-017	MAINTENANCE STEP, LH 206A/B
	X					D206-628-018	MAINTENANCE STEP, RH 206A/B
		X				D206-628-027	MAINTENANCE STEP, LH 206L/L-1/L-3/L-4
			X			D206-628-028	MAINTENANCE STEP, RH 206L/L-1/L-3/L-4
				X		D206-628-037	MAINTENANCE STEP, LH 407
					X	D206-628-038	MAINTENANCE STEP, RH 407
2	2			2	2	D2731-3RG	MOUNTING LUG
		2	2			D2731-7RG	MOUNTING LUG
2	2			2	2	D3394-1RG	MOUNTING LUG
		2	2			D3394-3RG	MOUNTING LUG
2	2	2	2	2	2	D4309-1	BUSHING
		1		1		D4342-041	MAINTENANCE STEP, LH
			1		1	D4342-042	MAINTENANCE STEP, RH
1						D4358-041	MAINTENANCE STEP, LH
	1					D4358-042	MAINTENANCE STEP, RH
4	4	4	4	4	4	AN4-12A	BOLT
		4	4			AN4-13A	BOLT
2	2	2	2	2	2	AN4-15A	BOLT
6	6	6	6	6	6	MS21042-4	NUT
6	6	6	6	6	6	NAS1149D0463J	WASHER (AN960JD416)

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Revision: G  
Date: 11.02.25

